

Date: Monday, 19/11/2007 2:22:59 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD  
Job Number : 35702  
Estimate Number : 11351  
P.O. Number : *N/A* Part Number : D33405  
This Issue : 19/11/2007 S.O. No. : *N/A* Drawing Number : D3340 REV B  
Prsht Rev. : NC Project Number : N/A  
First Issue : 13/11/2007 Type : PURCHASED PARTS Drawing Revision : B  
Previous Run : 25189 Material : *N/A*  
Written By : *[Signature]* Due Date : 30/11/2007 Qty: 12 Um: Each  
Checked & Approved By : *[Signature]*  
Comment : Est: A 05.11.10 Preliminary issue AP/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S19GA 1010/1025/A21/6aA SHEET .040



Comment: Qty.: 0.4353 sf(s)/Unit Total : 5.2240 sf(s)

1010/1025/A21/6aA SHEET .040

(M1010S19GA) M1010S20GA SEE W/D CHG. 07.12.10

Batch: 104921 B 07-12-11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3340

Dwg Rev: B B 07-12-11

Prog Rev: B

2-Deburr if necessary B 07-12-11

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*5/12/11* *counts* *(12)* *check*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on brake as per Dwg D3340

*SB* *07/12/12*

Date: Monday, 19/11/2007 2:22:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35702

Part Number: D33405

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/12 (x12) counts

7.0

POWDER COATING

POWDER COATING



M10 5642



(12x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m.p. 07/12/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-13

(x12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST500

AS 07/12/13

x12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/14

Job Completion



u 07.12.14

Date: Tuesday, 11/13/2007 1:34:00 PM  
User: Kim Johnston

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 35702	
Estimate Number : 11351	
P.O. Number :	Part Number : D33405
This Issue : 11/13/2007 S.O. No. :	Drawing Number : D3340 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 25189	Material :
Written By :	Due Date : 11/30/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: A 05.11.10 Preliminary issue AP/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-5

Material release note required

*Water plate Est done*

2.0	D33405F	Wearplate
-----	---------	-----------



Comment: Qty.: 1.0000 U(s)/Unit Total : 12.0000 U(s)  
Wearshoe

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

Form on brake as per Dwg D3340 using Jigs DT and DT

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.12.10	1	USE M1010520GA INSTEAD OF M1010519GA <del>M1010518GA</del> M1010520GA CP 07.12.20				CP 07.12.10 PS QSI 042	✓ 07.12.11	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.12.10	1	WEAR PLATES RU THRU 0.033"	<i>CP</i> 07.12.10 PS QSI 042	USE SCRAP & USE 18GA material RU ENG ERROR			<i>CP</i> 07.12.10 PS QSI 042	<i>CP</i> DIS REGRD <i>CP</i> 07.12.10

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:34:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35702

Part Number: D33405

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

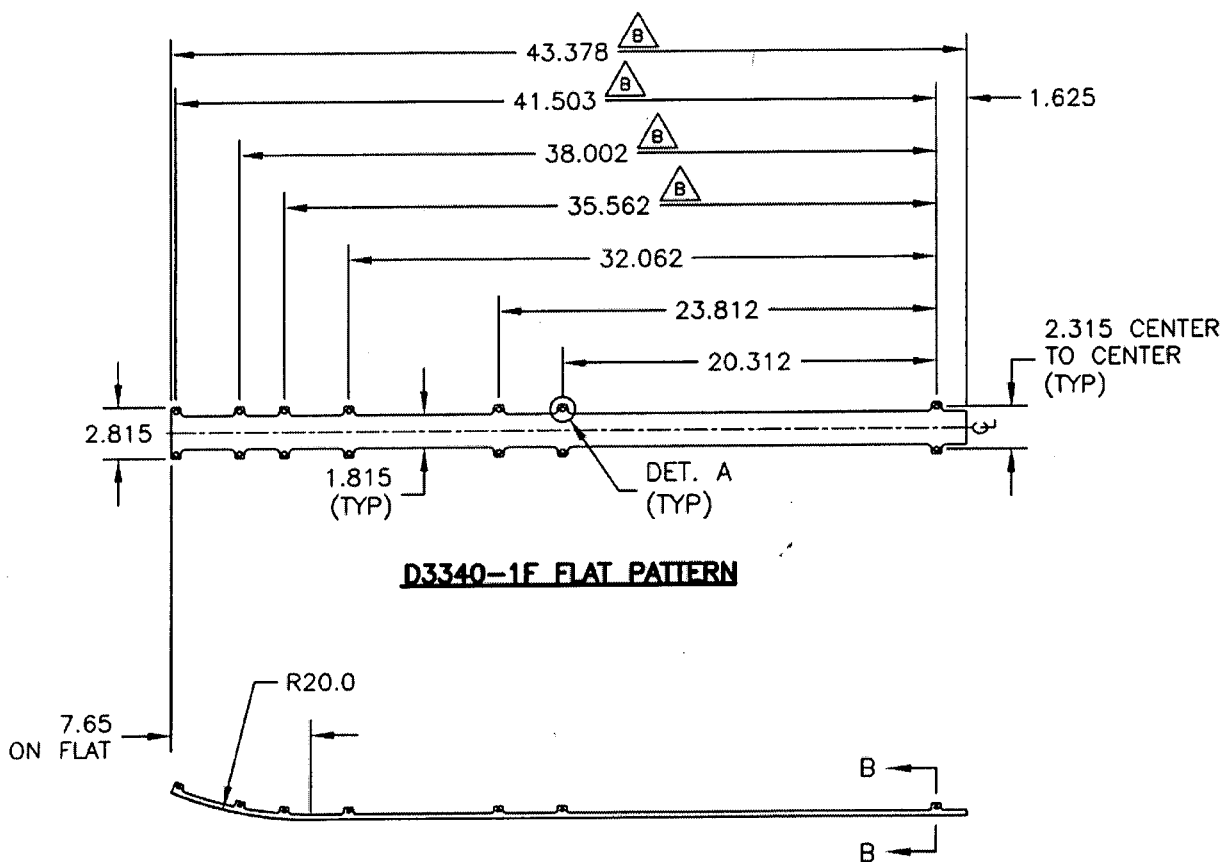
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10
A	05.06.09	NEW ISSUE	
B	05.11.22	ADD DETAIL D, CORRECT FLAT PATTERNS D3340-1/-3/-7/-9/-13/-19/-23	

RELEASED  
05.11.28 *[Signature]*



**D3340-1 FORWARD SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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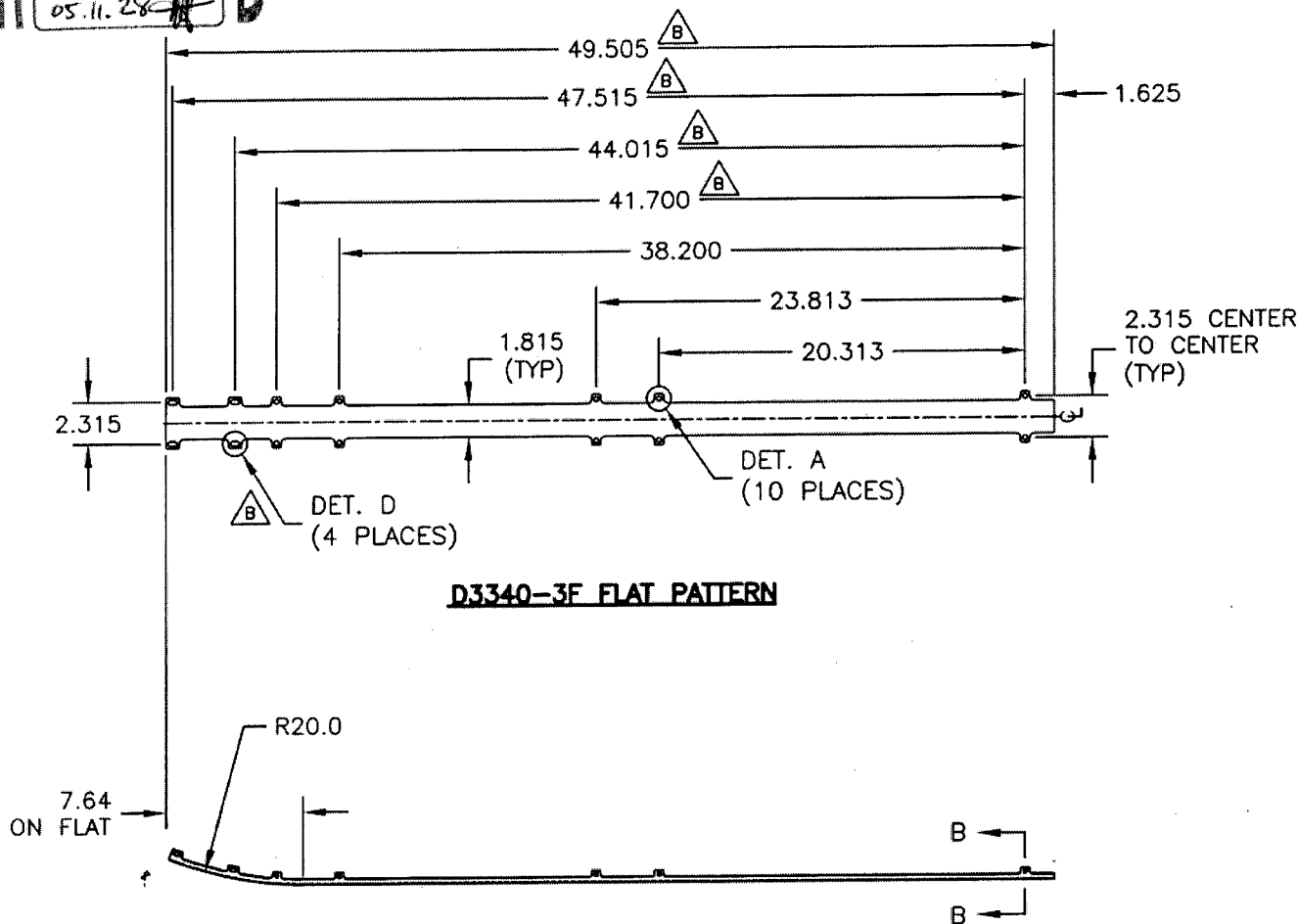
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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**D3340-3F FLAT PATTERN**

**D3340-3 FORWARD SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
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- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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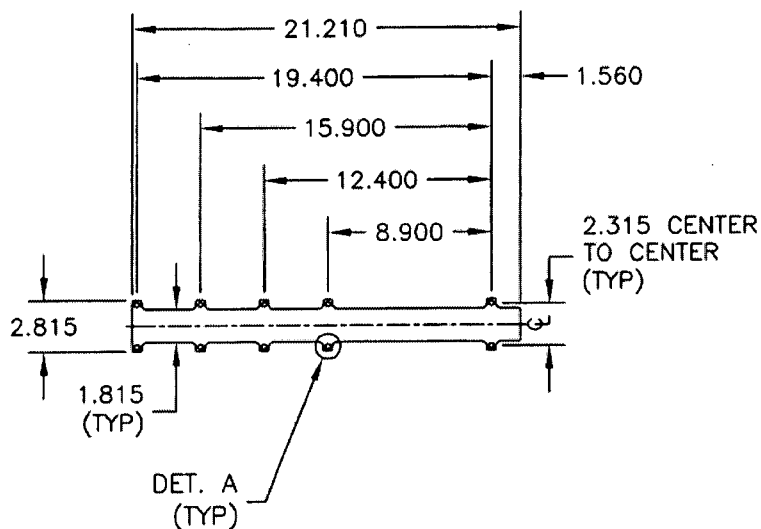
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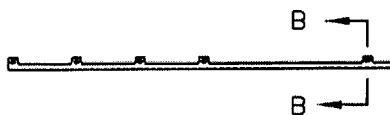


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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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**D3340-5F FLAT PATTERN**



**D3340-5 FORWARD SKIDTUBE PROTECTOR**

**NOTES:**



- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL, 18 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

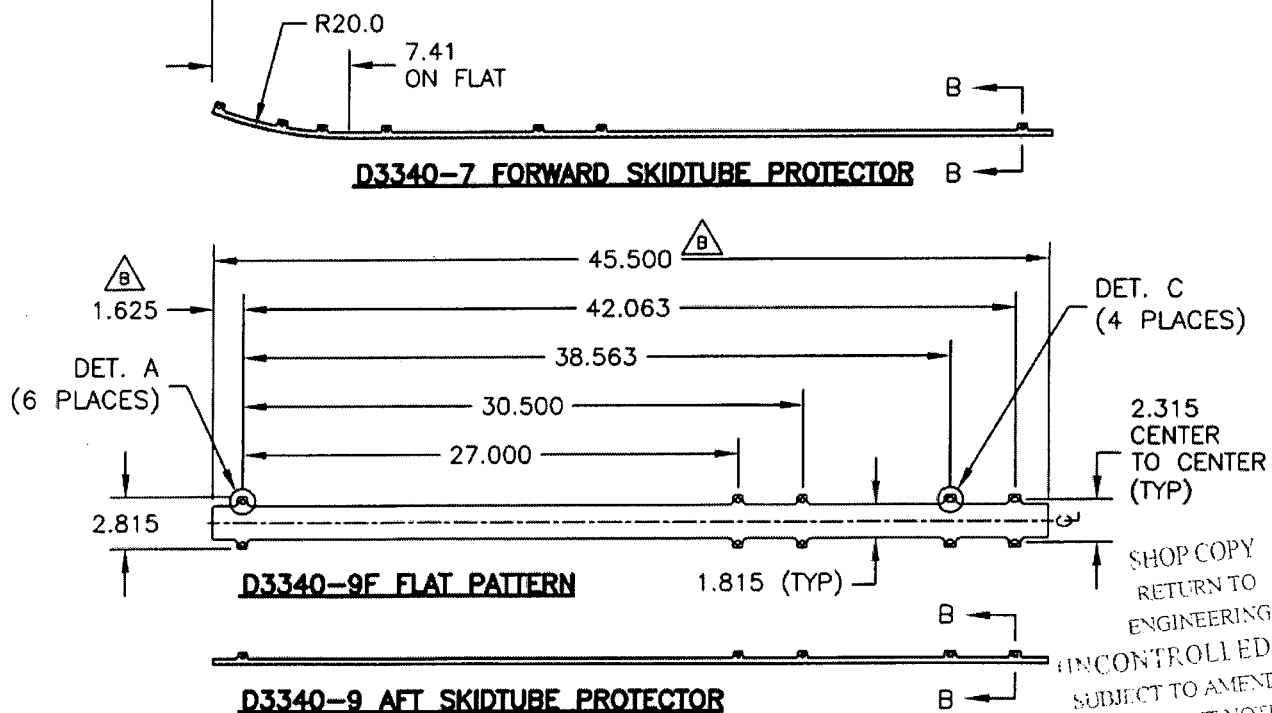
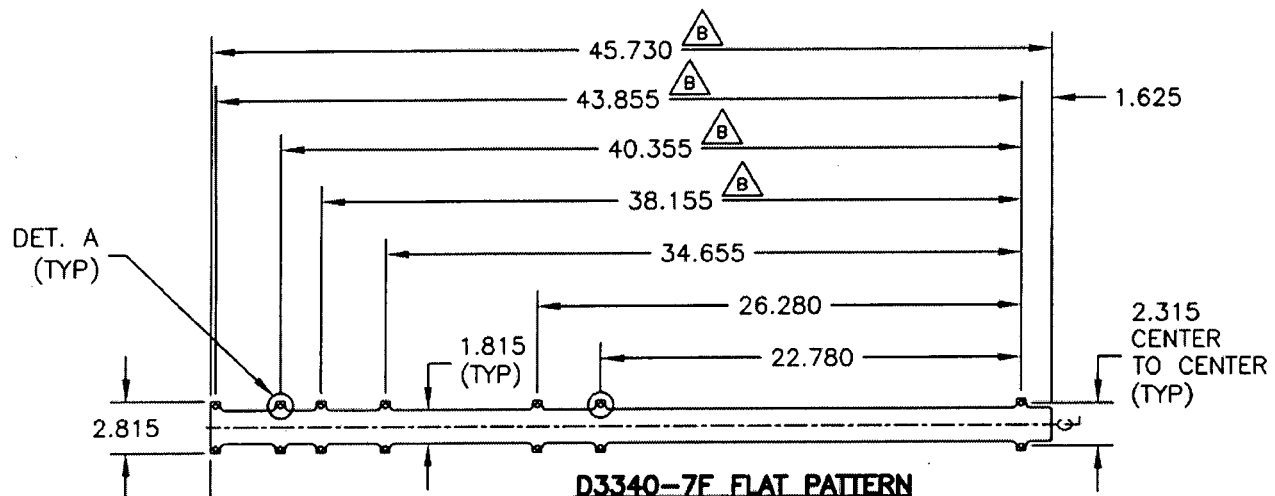
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**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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05.11.28

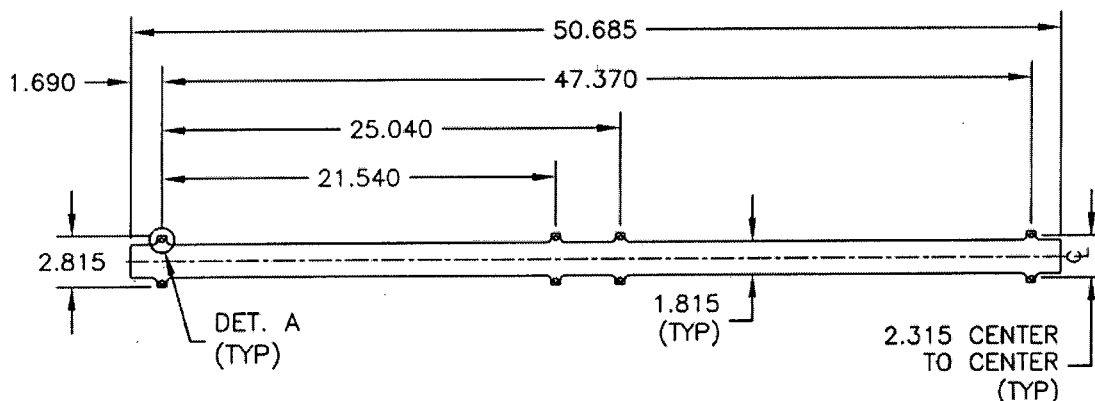
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**D3340-11F FLAT PATTERN**



**D3340-11 CENTER SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

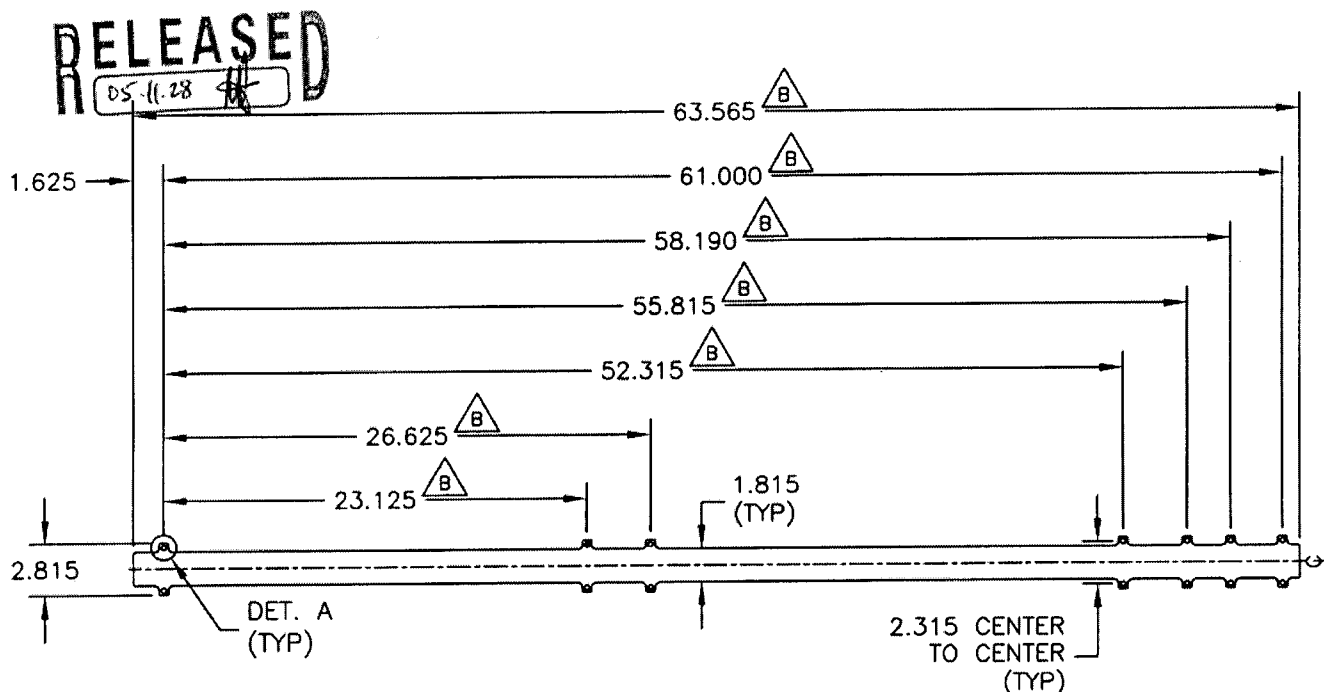
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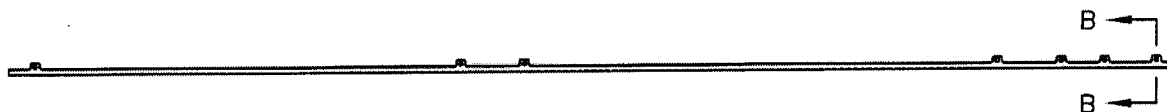
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



**D3340-13F FLAT PATTERN**



**D3340-13 AFT SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

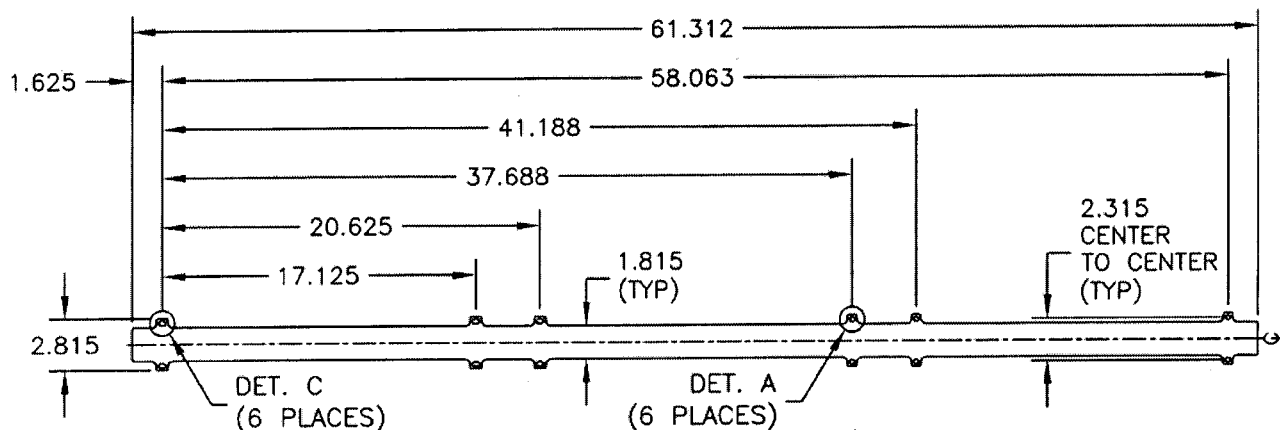
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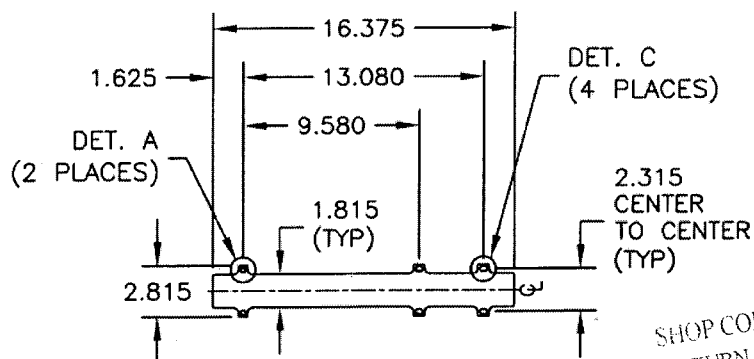
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



**D3340-15F FLAT PATTERN**

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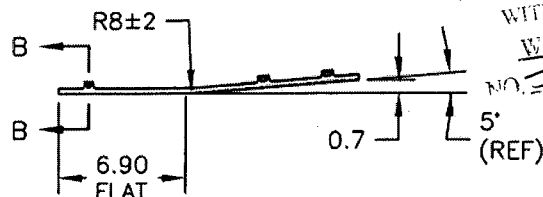
**D3340-15 CENTER SKIDTUBE PROTECTOR**



**D3340-17F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5:6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX



**D3340-17 AFT SKIDTUBE PROTECTOR**

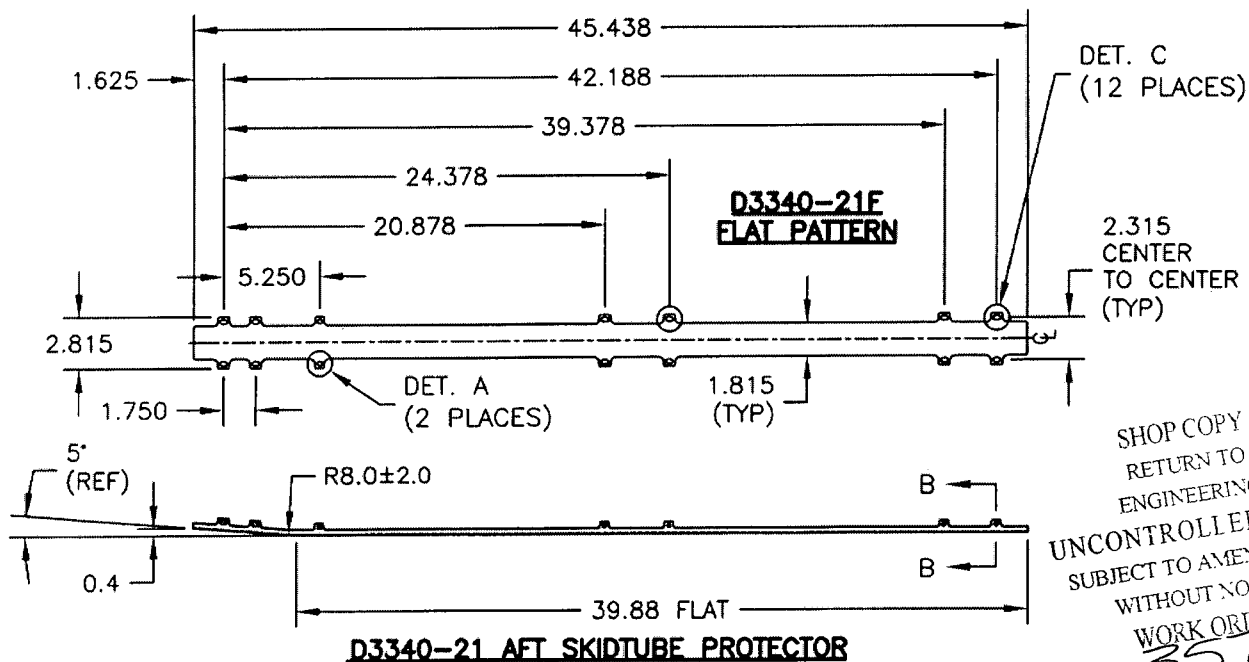
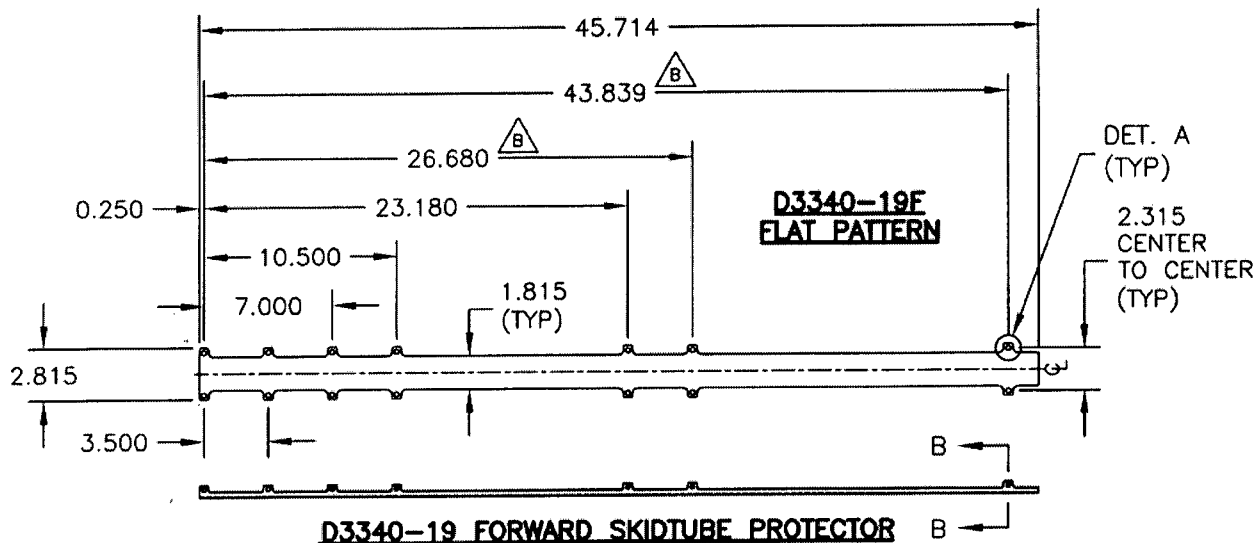
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP CORNERS 0.063 MAX

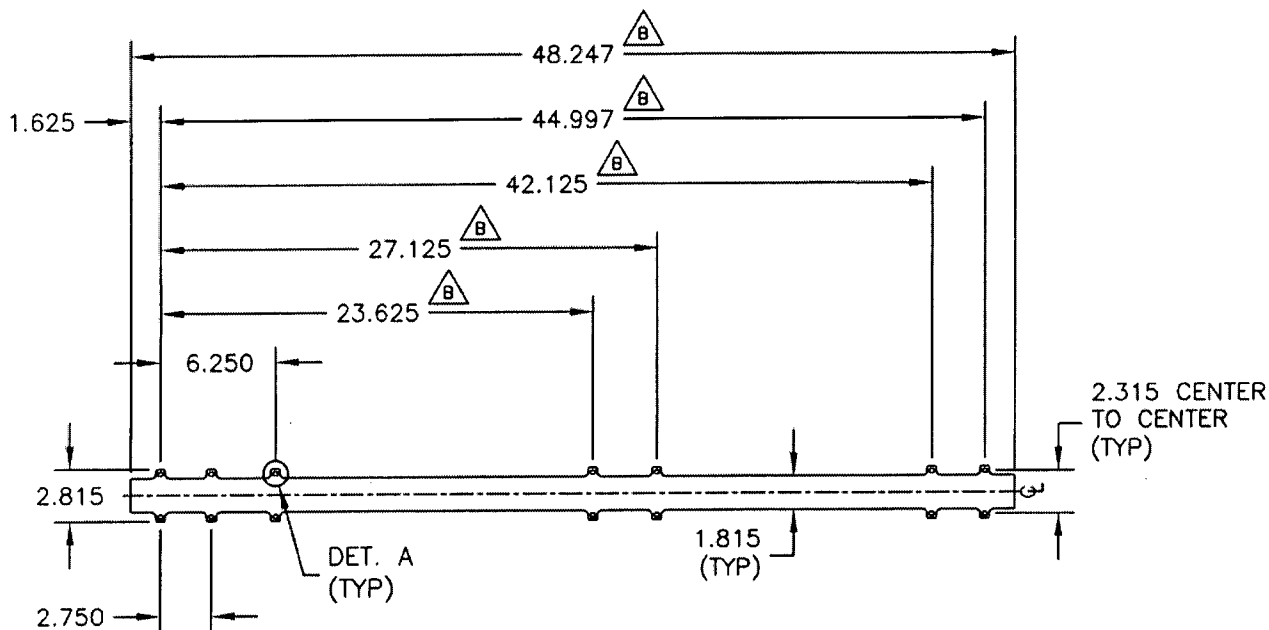
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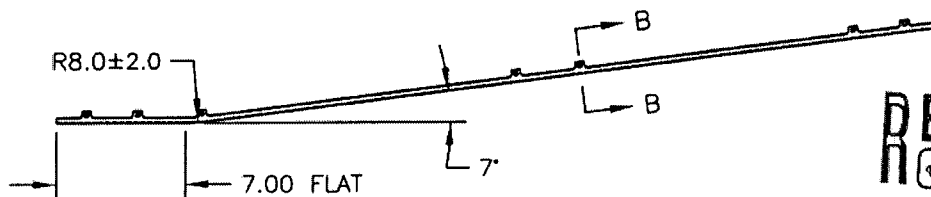
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



**D3340-23F FLAT PATTERN**



**D3340-23 AFT FLOAT SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

**RELEASED**  
05.11.28 *[Signature]*

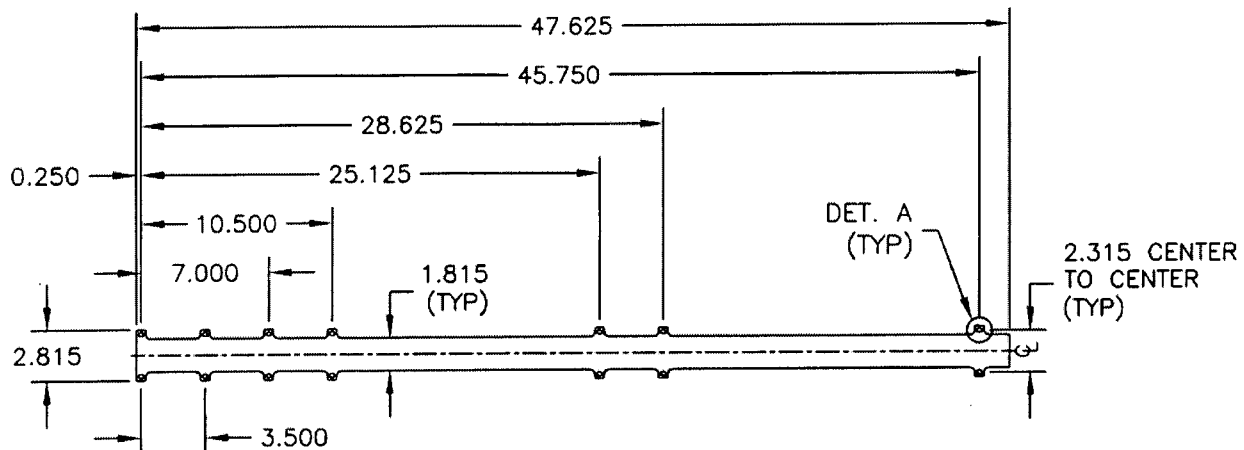
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



**D3340-25F FLAT PATTERN**

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**D3340-25 FORWARD SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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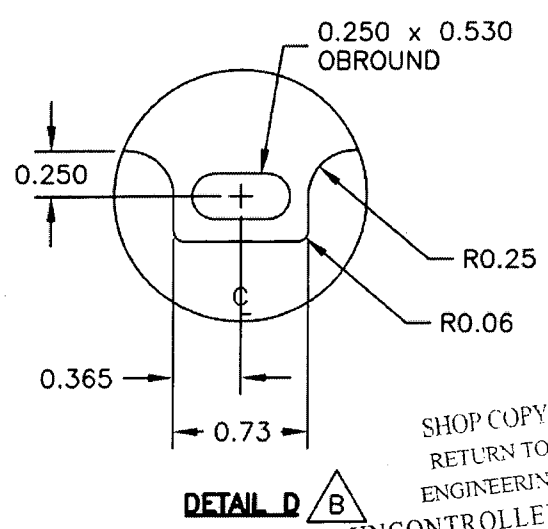
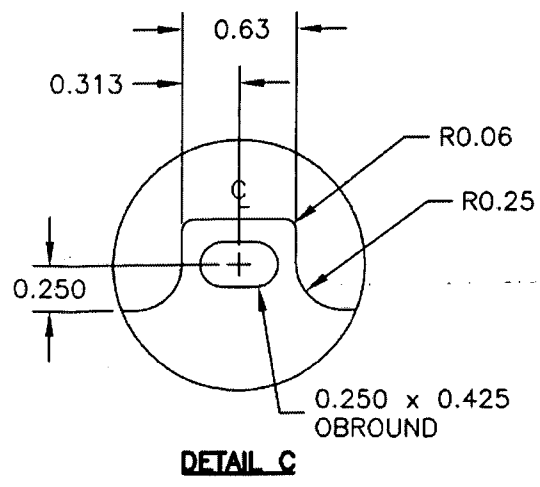
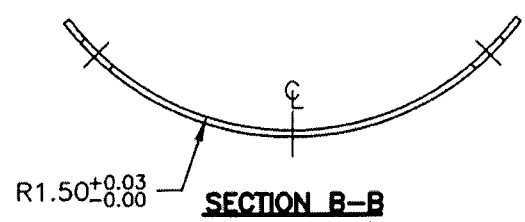
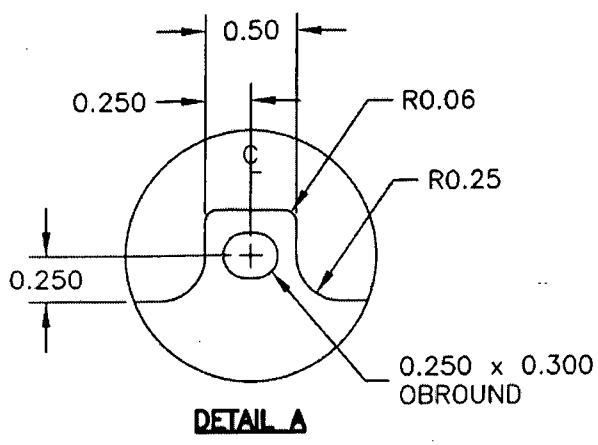
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